

Work Order ID 104995

104995

Page 1

July-23-13 12:58:32 PM

Item ID: D3188-1M Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: SPACEPOD BODY LH
 Start Date: 7/26/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/26/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 13-07-25 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	Rev F								

100 0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O:

20830

Description: D3188-1MBODY

Ship: QTY (8) D2213 Spacers

Ship to Delastek (1) D0600-XXX label

Batch: N/A

08/15/02/27

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

0.00

CL 13/08/07 (1)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

0.00

P 13/14/16 (1)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

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Page 2

July-23-13 12:58:32 PM

Item ID: D3188-1M Accept *N900040100* Setup Start *NS1*
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 Item Name: SPACEPOD BODY LH
 Start Date: 7/26/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/26/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				/			DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								FEB 26 2015
130	Identify as per dwg & Stock Location: CA2	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

W 15-02-26

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											
FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Picklist Print

July-23-13 12:58:32 PM

Page 1

Work Order ID: 104995
Parent Item: D3188-1M
Parent Item Name: SPACEPOD BODY LH

Start Date: 7/26/13

Required Date: 7/26/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
IPP rev B revc dwg 07.01.11 ec
IPP rev C revD dwg 07.03.07 ec
IPP rev D rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213 Insert		Manufactured	No			100	Each	106.0000	8	8		CX 13/08/07	(8)
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		106							
				30809		106							
D3188-1P Spacepod Body		Purchased	No			110	Each	0.0000	1	1		CX 13/10/16	(1)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

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☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
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		☐ Over/Under tolerance
		☐ Part Incorrect
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		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

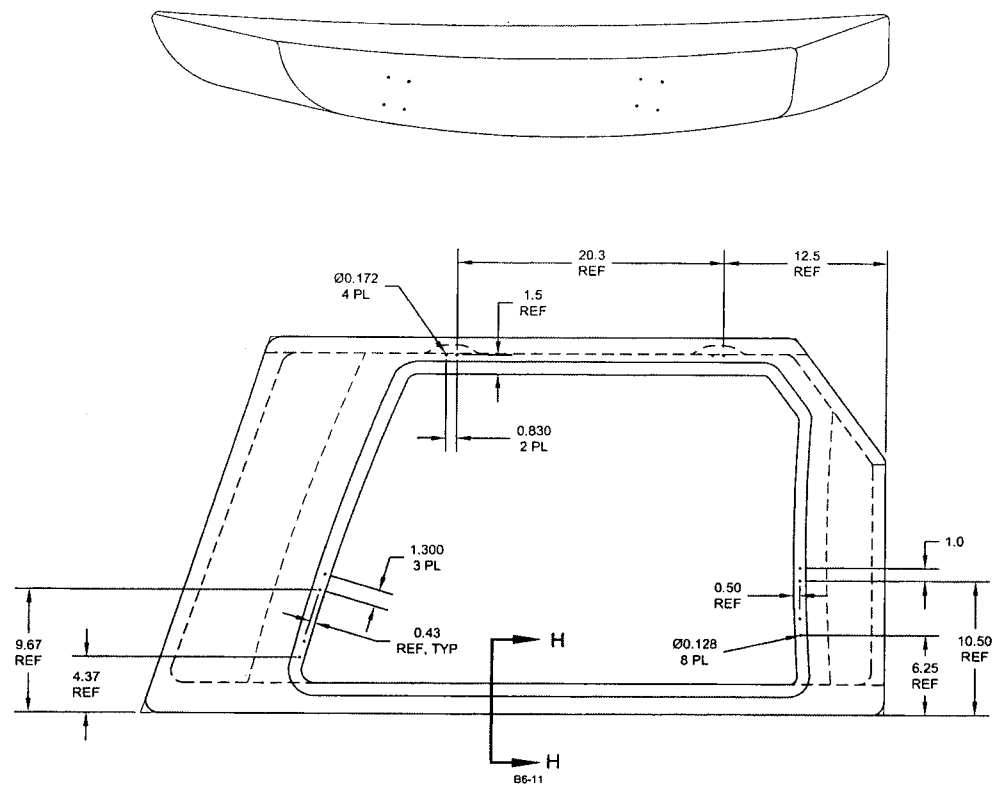
9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

104995 ML3
13-07-25

RELEASED
2009-10-20

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0800-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 1 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

104995



D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

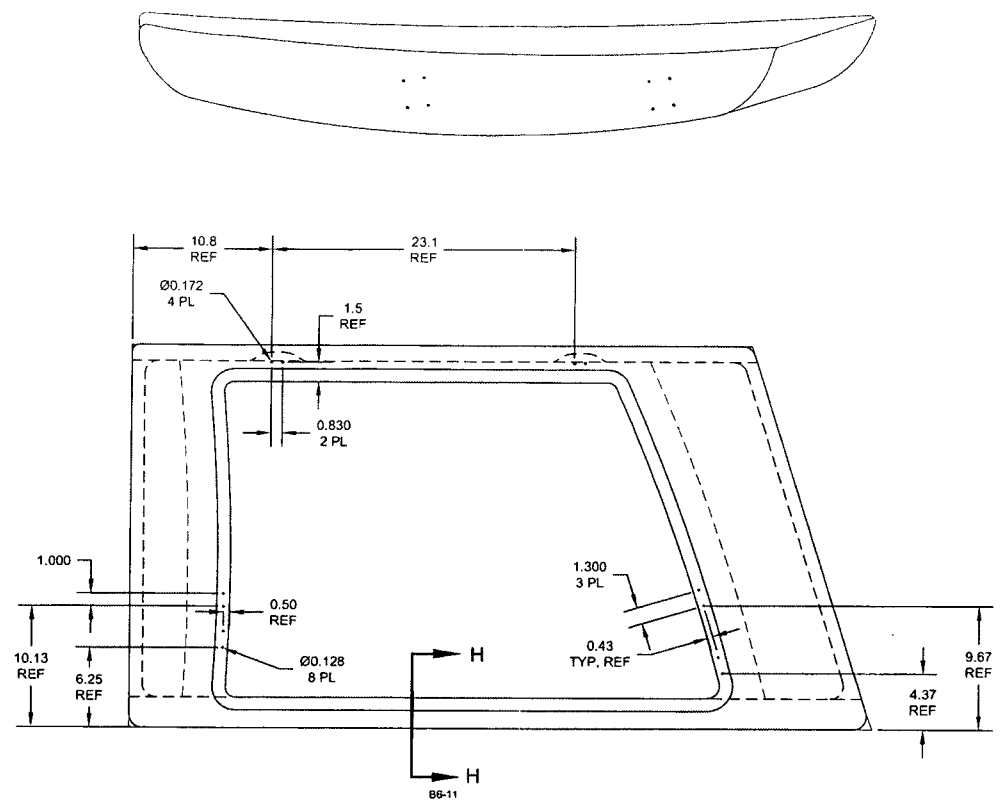
RELEASED
2009-10-20
MP

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 2 OF 11
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D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

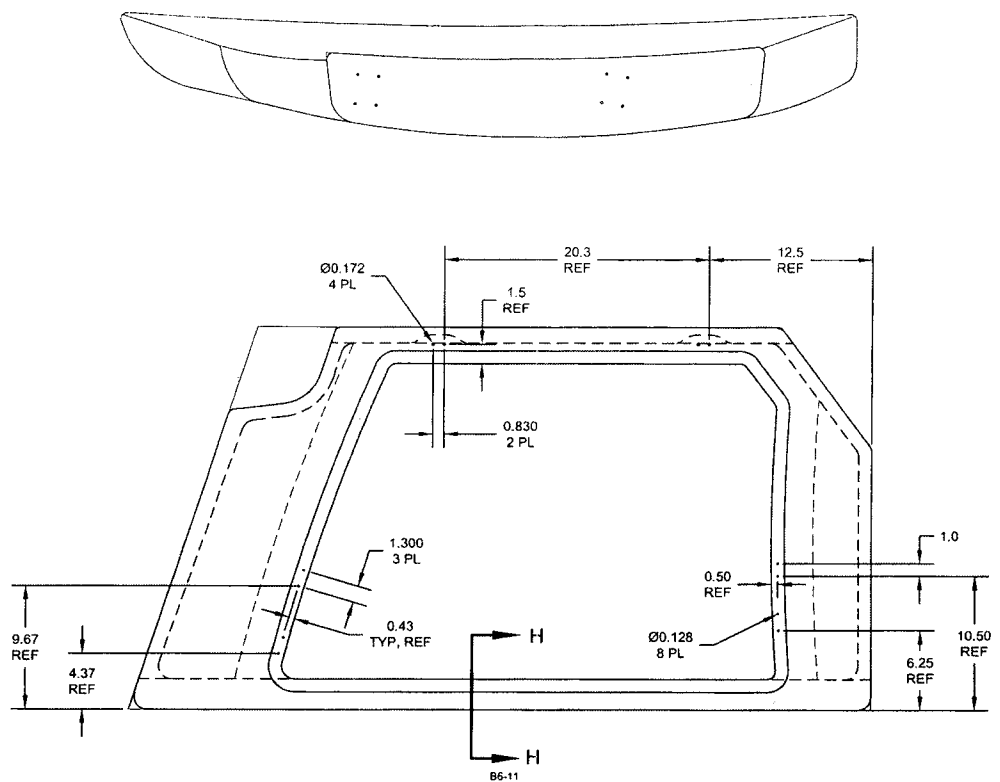
RELEASED
2009-10-20
NP

- NOTES:**
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3188-2 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD	
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 3 OF 11
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8 7 6 5 4 3 2 1

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D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

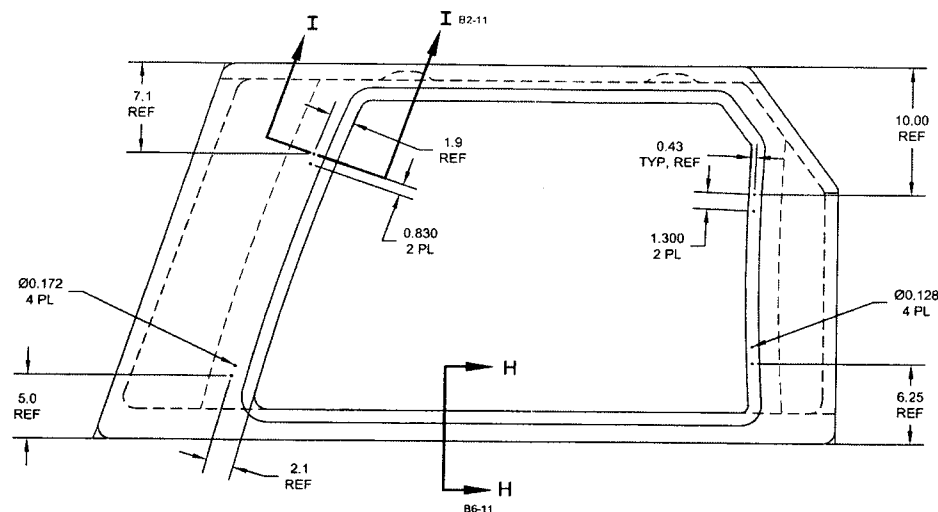
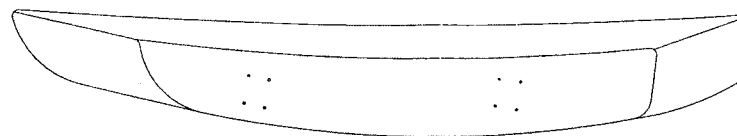
RELEASED
2009-10-20

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

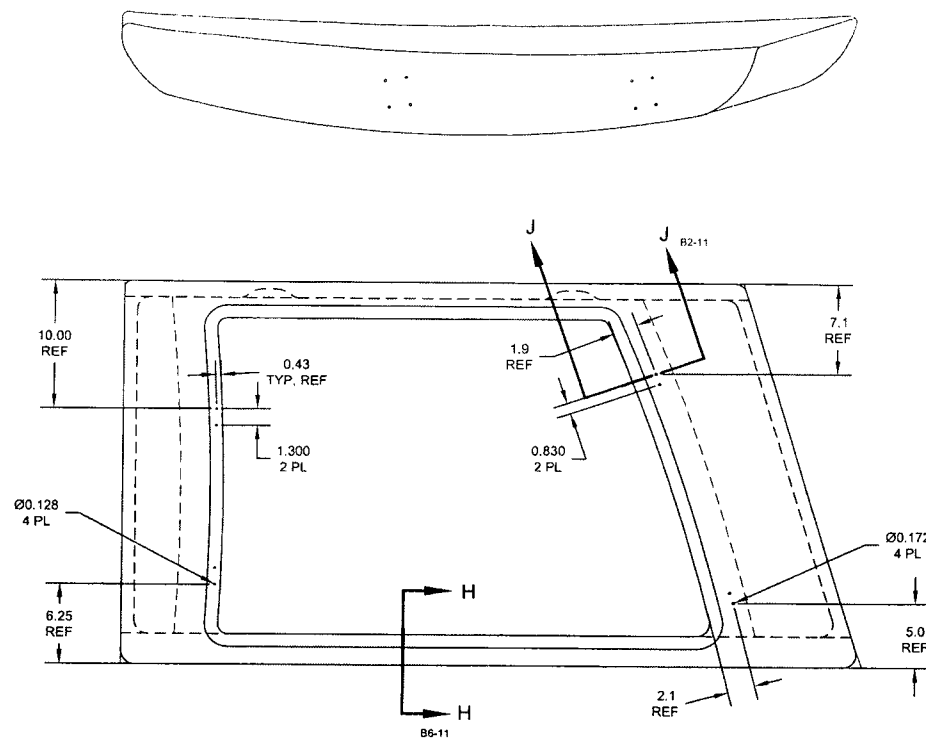
RELEASED
2009-10-20

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
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D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

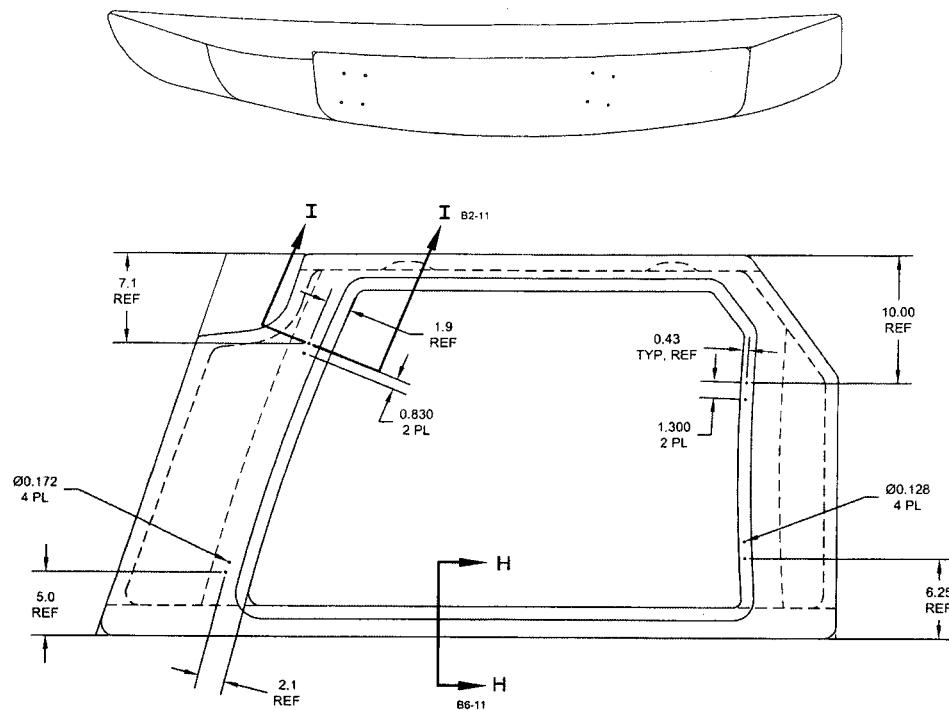
RELEASED
2009-10-20

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
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D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

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2009-10-20
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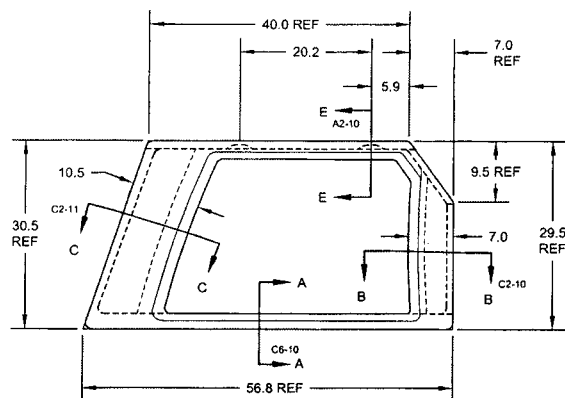
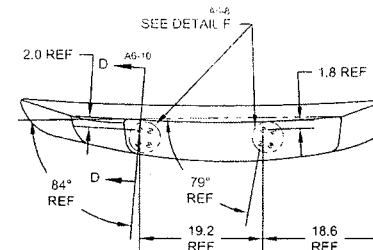
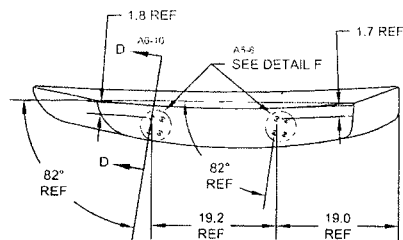
NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

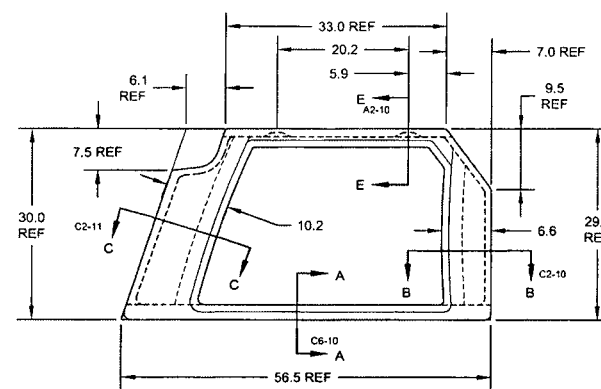
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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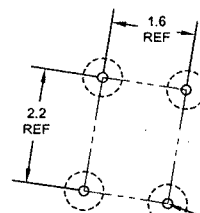
104998



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F

INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A8-10

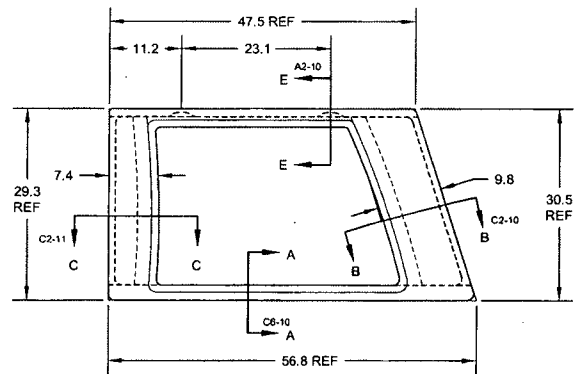
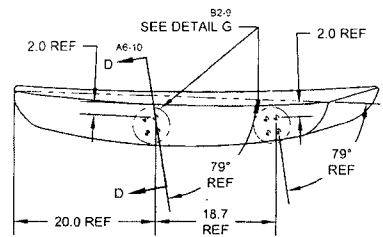
D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

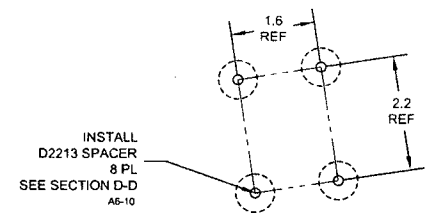
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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104995



D3186-2M SPACEPOD BODY



DETAIL G D6-9

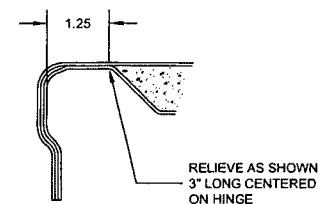
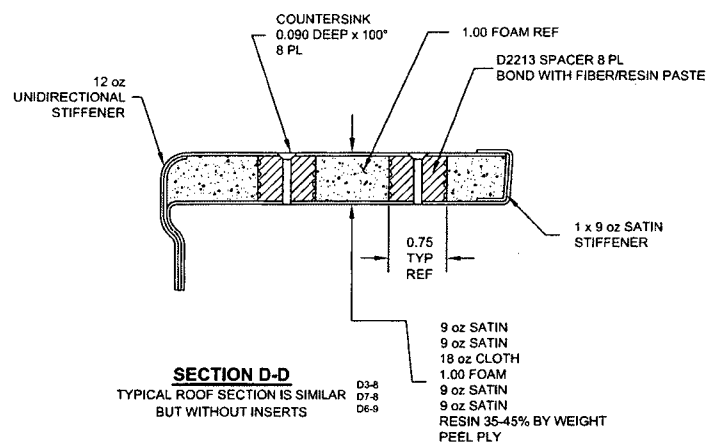
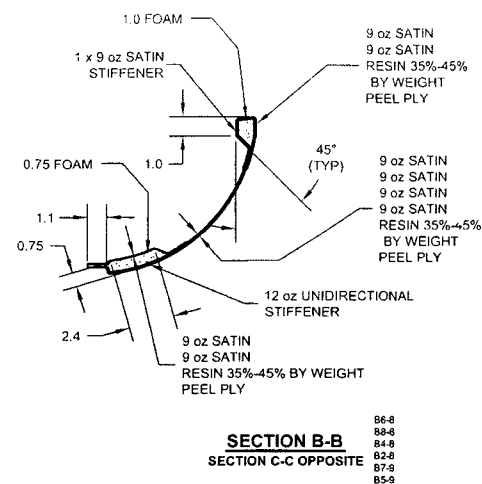
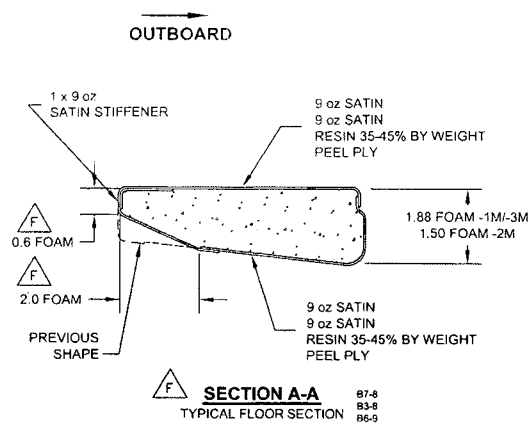
RELEASED
2009-10-20

D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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8 7 6 5 4 3 2 1

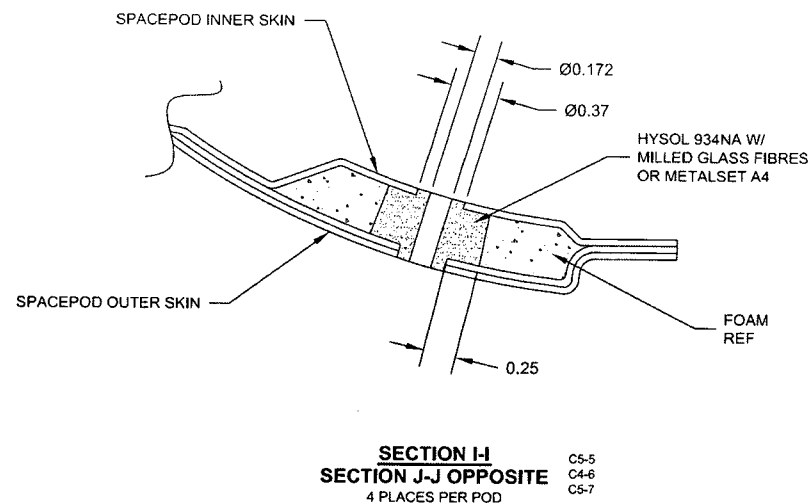
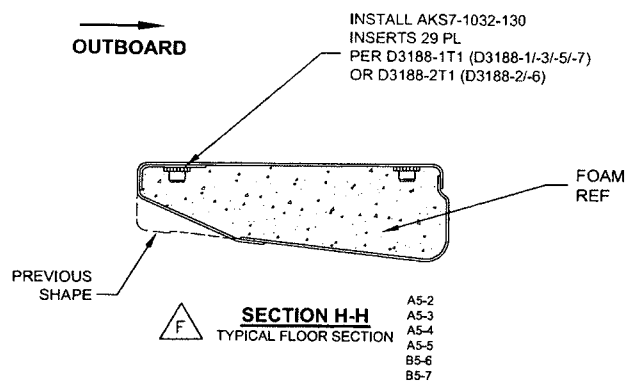
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DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. F
MFG. APPR.	JB	D3188	SHEET 10 OF 11
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	SPACEPOD BODY	NTS
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2009-10-20
WJ

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WJ	DRAWING NO.	REV. F
MFG. APPR.	WJ	D3188	SHEET 11 OF 11
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SPACEPOD BODY	NTS
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DELASTEK Inc.
2699 5e Avenue
Local 14, C.P. 10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	49485
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
15-10-2013	29-08-2013	23793	Chantal Lavoie	20830	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Mathieu Doucet, ext.690	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0058	Line 1 D3186-1P Spacepod Door LH Dwg. Rév.: E Serial # 56134 Lot # 56134	
1	0	1	DKC134-0070	Line 2 N° D3188-1P, Spacepod Body LH Dwg. Rév.: F Serial # 55110 Lot # 55110	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2013-08-22 07:55:10
Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE	Nom Dessin : SPACEPOD BODY LH
Numéro Job : 55110	Numéro Article : DKC134-0070
Numéro : 3766	Numéro Dessin : -
Numéro B.A. :	Projet Numéro : DK-362
Cette fois : 2013-08-22 No. :	Révision dessin :
Prsht Rev. : NC	Matériel : Fibre 7781 et résine 411-350
Prem. fois : - - Type :	Date Dûe : 2013-08-29 Qté : 1 Ud UNITE
Job précédente : 43681	26 sept
Écrit par : _____	
Vérifié & Approuvé par : _____	
Commentaires : N° de dessin: D3188-1 rev. F	

E.O.: N/A

Feuille de Procédé Rév.: 0 AMB0349 remplacé par
AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo
Comment	Qty.: 0.010 UNITE(s)/Unit Total : 0.010 UNITE(s) N° 83634, Frekote Loctite Wolo # de Lot: _____	
2.0	PRÉPARATION	Préparation du moule
		
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire la préparation du moule selon IF134-0019. Date: _____ Sceau: _____	
3.0	AAC1885	Tissu à délaminer Release ply B
Comment	Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s) Tissu à délaminer Release ply B # de Lot: _____	
4.0	AAC1887	Wrightlon 5200 Bleu P3
Comment	Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: _____	
5.0	AC0885	Feutre de drainage N° Airweave N 10
Comment	Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)	

Date: Jeudi, 2013-08-22 07:55:10

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: SPACEPOD BODY LH

Numéro Job: 55110

Numéro DKC134-0070

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 11.40 VERGE(s)/Unit Total : 11.40 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-4291-1

8.0 AMB0213 WR1850 Roving 18oz. x 50"

Comment Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s)

WR1850 Roving 18oz. x 50" N° de Lot: 1-35539-1

9.0 AMB0511 N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

N° TG-13-U, Fiberglass 13 oz N° de Lot: 1-36302-1

10.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)

11.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0019.

Date: 4-09-13 Sceau: 4460RL

12.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-42170-1

14.0 AAC1540 Fibre de verre Miapoxy 66

Comment Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)

Fibre de verre Miapoxy 66 N° de Lot: 1-40092-2

15.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0019.

Date: 12/09/13 Sceau: 4460RL



Date: Jeudi, 2013-08-22 07:55:10

Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD BODY LH
Numéro Job:	55110	Numéro	DKC134-0070

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

16.0	AMB0355	ATC core-cell A500 plain 4'x8' 1" thick
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Comment Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-38256-1

17.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
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Comment Qty.: 0.200 LITRE(s)/Unit Total : 0.200 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-42170-1

18.0	AMB0286	Catalyst N° DDM-9
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Comment Qty.: 0.0064 GALLON(s)/Unit Total : 0.0064 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

19.0	AAC1611	Polybond B46F
------	---------	---------------

Comment Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)
Polybond B46F N° de Lot: 1-38189-1

20.0	TAILLAGE	Faire le taillage du matériel
------	----------	-------------------------------



Comment Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0019.

Date: 16/09/13 Sceau: 4460 RL



21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Comment Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-42170-1

22.0	AMB0286	Catalyst N° DDM-9
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Comment Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

23.0	FINITION	Finition Générale
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Comment Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Sceller les foam core selon IF134-0019.

Date: 16-09-13 Sceau: 4460 RL

24.0	PERCAGE	Perçage de trous
------	---------	------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Perçer les foam core selon IF134-0019.

Date: 16-09-13 Sceau: 4460 RL

Date: Jeudi, 2013-08-22 07:55:10

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: SPACEPOD BODY LH	
Numéro Job: 55110	Numéro: DKC134-0070	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
25.0	AAC1611	Polybond B46F
Comment Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s) Polybond B46F N° de Lot: <u>1-3889-1</u>		
26.0	ASSEMBLAGE	Assemblage mécanique
 		
Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs Installer les foam core selon IF134-0019. Date: <u>17/09/13</u> Sceau: <u>4460 R.L.</u> 		
27.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-41428-1</u>		
28.0	FINITION	Finition Générale
 		
Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs Usiner les foam core selon IF134-0019. Date: <u>19/09/13</u> Sceau: 		
29.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-42176-1</u>		
30.0	AMB0286	Catalyst N° DDM-9
Comment Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
31.0	LAMINAGE	Faire le laminage
 		
Comment Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs Laminer les plis de 9oz selon IF134-0019. Date: <u>24/09/13</u> Sceau: <u>4460 R.L.</u> 		
32.0	TRIMAGE	Trimage
 		
Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs Faire le taillage selon IF134-0021. Date: <u>25-09/13</u> Sceau: <u>4460 R.L.</u>		

Date: Jeudi, 2013-08-22 07:55:10

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 55110

Nom Dessin: SPACEPOD BODY LH
Numéro DKC134-0070

Numéro Job:



Séq.: Machine ou Opération: Description :

33.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0144 GALLON(s)/Unit Total: 0.0144 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

34.0 AAC1540 Fibre de verre Miapoxy 66

Comment Qty.: 0.0420 GALLON(s)/Unit Total: 0.0420 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-40769-1

35.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.450 KILOGRAMME(s)/Unit Total: 0.450 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-42176-1

36.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage après taillage selon IF134-0019.

Date: 26/08/13 Sceau: 4460 R.L.



37.0 AAC1610 Spacer N° D2213

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Spacer N° D2213 N° de Lot: 1-42164-2

38.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG 0097.

Date: 27/08/13 Sceau: 4460 R.L.



39.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-42451-1

40.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-41909-3

41.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Date: 1/10/13 Sceau: 4460 R.L.



Date: Jeudi, 2013-08-22 07:55:10

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: SPACEPOD BODY LH	
Numéro Job: 55110		Numéro DKC134-0070	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
42.0	PRIMER	Application primer	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Préparer et appliquer le primer selon IG 0008.			
Date: <u>2/10/13</u> Sceau:  # de fiche de mélange: <u>6475</u>			
43.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)			
N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-41428-1</u>			
44.0	FINITION	Finition Générale	
			
Comment Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs			
Faire les réparations de finition s'il y a lieu selon IG 0008.			
Date: <u>4/10/13</u> Sceau: <u>4460 R.L.</u> 			
45.0	AAC1021	Dupont Primer N° 7704S	
Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)			
Dupont Primer N° 7704S N° de Lot: <u>1-37302-1</u>			
46.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)			
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-40542-1</u>			
47.0	PRIMER	Application primer	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Préparer et appliquer le primer selon IG 0008.			
Date: <u>10-10-13</u> Sceau:  # de fiche de mélange: <u>6480</u>			
48.0	INSPEC FINAL	Inspection finale	
			
Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.			
Date: _____ Sceau: _____ Initiales: _____			